

Work Order ID 109264

November-18-13 8:48:29 AM

109264

~~U/R~~

Page 1

Item ID: D3805-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Ass'y Fwd Low Gear

Start Date: 11/18/13 Start Qty: 11.00

11

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 11.00

11

Customer:

Reference: rework

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3805

BUR

0.00

150

Small Fab

Small Fab

Memo

0.00

PULL FROM STK:

3 X D3805-041 B91147

4 X D3805-041 B93649

1 X D3805-041 B76779

2 X D3805-041 B91144

1 X D3805-041 B93651

REMOVE GASKET - DISCARD

REMOVE ADHESIVE/CLEAN PROPERLY

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

7 CF 13-11-20



7 13-11-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: PA Date: 13/12/19QA Closed: PA Date: 13/12/18

Work Order: <u>109264</u> Part No. <u>D3805-041</u> NCR No. <u>13-3344</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		13/12/3	150	1	USE Rockguard 4715A, 0.020 - 0.040 thick, instead of gasket.	DAS 12 9-89 13/12/3	Acceptable deviation. Minor change based on similar FAA approved wearplates. DAS 12 9-89 13/12/3	DAS 12 9-89 13/12/3	 13-11-21	 13-11-21
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

11

Cust Item ID:

Start Date: 11/18/13 **Start Qty:** 11.00

Required Date: 11/18/13 **Req'd Qty:** 11.00

11

Customer:

Reference: rework

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

0.00

165

0.00

Small Fab

Memo

APPLY A LAYER OF ROCKGUARD AS PER DRWG
M 127155

13-11-21

166

QC5- Inspect part completeness to step on W/O	0.00
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0.00

166

0.00

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: FIP-001 0.00

0.00

170

0,00

Packaging

Memo

Packaging

~~RE-IDENTIFY USING NEW B/N~~

Work Order ID 109264

November-18-13 8:48:29 AM

109264

Page 3

Item ID: D3805-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Ass'Y Fwd Low Gear

Start Date: 11/18/13 Start Qty: 11.00

11

Cust Item ID:

Required Date: 11/18/13 Req'd Qty: 11.00

11

Customer:

Reference: rework

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

13/12/13

213-125

POSITIVE RECALL
EFFECTIVE 13/11/13 AUTH h
RELEASED CP DATE 13/12/13

Picklist Print

November-18-13 8:48:29 AM

Page 1

Work Order ID: 109264

Parent Item: D3805-041

Parent Item Name: Wearplate Ass'Y Fwd Low Gear

Start Date: 11/18/13

Required Date: 11/18/13

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-041 Wearplate Ass'Y Fwd Low Gear		Manufactured	No				Each	0.0000		11			

B91147 (7) h

8

7

6

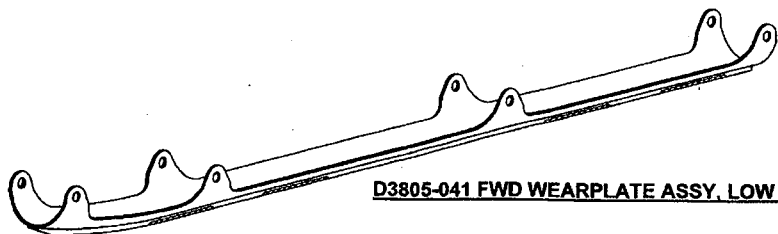
5

4

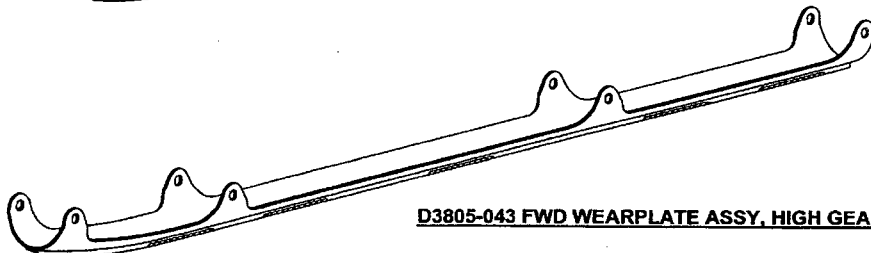
3

2

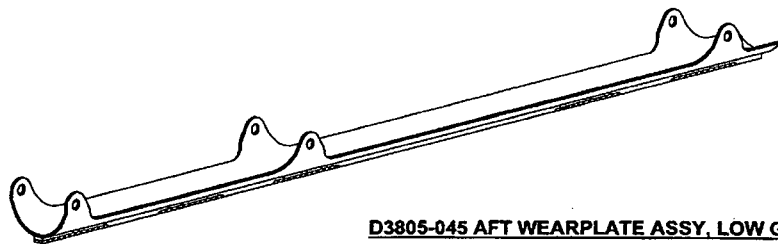
1



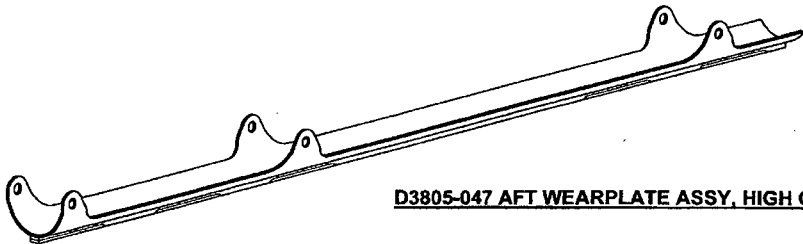
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

Remove ITEMS 19, 20,
21 & 22, ADD ROLLEAD

UNDER REVIEW

DB 13.10.06

RELEASED

2011-10-03

w/o 109264

B	REVISED D3805-1F-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART 11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	47		DART AEROSPACE USA, INC.	
DRAWN	30		KENT, WA	
CHECKED	11		DRAWING NO. D3805	
MFG. APPR.	11		REV. B	
APPROVED	11		SHEET 1 OF 8	
DE APPR.	11		TITLE WEARPLATE ASSY	
DATE	11.09.16		SCALE NTS	
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List Lots

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November-18-13 7:17:33 AM

Criteria : Item ID: 'D3805-041', 'D3805-043', 'D3805-043RevA', 'D3805-045', 'D3805-047', 'D3805-047RevA' All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
D3805-041 Wearplate Ass'Y Fwd Low Gear	Main Warehouse FP001	91147	10/23/13	3.0000		QC21	
	Main Warehouse FP001	93649	10/22/13	4.0000		QC21	
	Main Warehouse FP002	76779	10/03/13	1.0000		QC21	
	Main Warehouse FP002	91144	10/03/13	2.0000		QC21	
	Main Warehouse FP002	93651	10/03/13	1.0000		QC21	
Total:				11.0000			
D3805-043 Wearplate Ass'Y Fwd High Gear	Main Warehouse FP001	77584	9/11/13	2.0000		QC21	
	Main Warehouse FP002	86277	11/14/13	7.0000		QC21	
	Total:			9.0000			
D3805-045 Wearplate Ass'Y Aft Low Gear	Main Warehouse FP001	93654	10/23/13	4.0000		QC21	
	Main Warehouse FP002	73817	10/03/13	1.0000		QC21	
	Main Warehouse FP002	74896	10/03/13	1.0000		QC21	
	Main Warehouse FP002	87186	10/03/13	4.0000		QC21	
Total:				10.0000			

109264

109265

109266

List Lots

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November-18-13 7:17:33 AM

Criteria : Item ID: 'D3805-041', 'D3805-043', 'D3805-043RevA', 'D3805-045', 'D3805-047', 'D3805-047RevA' All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID					Lot Code	
D3805-047	Main Warehouse	77585	8/08/13	2.0000		QC21	
Wearplate Ass`Y Aft High Gear	FP002						
	Main Warehouse	88968	8/08/13	1.0000		QC21	
	FP002						
Total:				3.0000			

109267

November-18-13 7:17:33 AM

List Lots

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Linda Lacelle

From: Mike Petsche
Sent: November-15-13 10:42 AM
To: Linda Lacelle
Cc: Marc Bellavance
Subject: RE: D3805

If it's actually worth the time to do that, then yes.

From: Linda Lacelle
Sent: Friday, November 15, 2013 10:41 AM
To: Mike Petsche
Cc: Marc Bellavance
Subject: RE: D3805

Sorry to continue on with this, but I just thought...If the only change is the gasket vs rocker guard, could we not just rework - remove the gasket and add the rocker guard?

From: Mike Petsche
Sent: November-15-13 10:39 AM
To: Linda Lacelle
Cc: Marc Bellavance
Subject: RE: D3805

If we don't NEED them.....maybe you should. We are submitting the latest changes to FAA in the next week or so.....

From: Linda Lacelle
Sent: Friday, November 15, 2013 10:07 AM
To: Mike Petsche
Cc: Marc Bellavance
Subject: RE: D3805

Right now they are just for stk, so, should we scrap them?

From: Mike Petsche
Sent: November-15-13 10:07 AM

To: Linda Lacelle
Cc: Marc Bellavance
Subject: RE: D3805

Are they for Ft. Rucker?

I don't THINK that we are supposed to ship them parts with gaskets anymore. If they are for someone else we can ship

From: Linda Lacelle
Sent: Friday, November 15, 2013 9:01 AM
To: Mike Petsche
Cc: Marc Bellavance
Subject: D3805
Importance: High

These are still U/R, we have some in stock, and have tubes to assemble, can we use them??

Linda Lacelle
Production manager
Dart Aerospace